

S116350



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D130-1048-011
Job Sheet 184194

Accounting Job RD17-1048-01



Part No: D130-1048-011

Job Qty: 1 ea

Part Name: EC130 Skidtube Installation, LH



Part Weight: 0 lbs

Job Created: 10/3/18

Due Date: 10/3/18

Type: R+D

Note: TBD DWG D130-1048-011 PRELIM DP verify DD 17.07.08

Ship Via:

Status: New

Job Tracking No:

Created By: Jesse White

Description:

PRELIMINARY
ISSUE

Priority: Medium

005774

DWG Rev. A

DAS
35
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/3/18	10/3/18	0.00	0.00	Start Up Handfinish		
110	HandFinish	1 pcs	10/3/18	10/3/18	0.00	0.50	HandFinish4		18-10-05
120	QC	1 pcs	10/3/18	10/3/18	0.00	0.00	QC5		15-10-05
130	Packaging	1 pcs	10/3/18	10/3/18	0.00	0.00	Packaging1-6		N/A
135	QC	1 pcs	10/3/18	10/3/18	0.00	0.00	QC4		
140	Packaging	1 pcs	10/3/18	10/3/18	0.00	0.00	Packaging3-2		
155	DC	1 pcs	10/3/18	10/3/18	0.00	0.00	DC		
165	QC21-SA	1 Ea	10/3/18	10/3/18	0.00	0.00	QC21		18-10-05

Part Op 110 - ASSEMBLE AS PER DWG

Descriptions: 130 - BAG AND ID HARDWARE.

140 - Identify and pack for shipping as per PPP D130-1048-011 Location: _____ PPP Rev: _____

155 - Photocopy blue file and create labels as per PPP D130-1048-011 chg 001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
22201BC120090L ST 575	Bolt	1 Ea (1 ea)	90-Start up Operation	5107718
23111AG120LE	Washer	1 Ea (1 ea)	90-Start up Operation	NA
AN3C5A ³⁵⁰	Bolt	8 Ea (8 ea)	90-Start up Operation	5082907
AN8C56A ^{GA197}	Bolt	3 Ea (3 ea)	90-Start up Operation	5109122
ASN52320BH120N ^{ST556}	Nut	1 Ea (1 ea)	90-Start up Operation	Fm135585
D130-1048-041	EC130 Skidtube Assembly, LH	1 Ea (1 ea)	90-Start up Operation	5113879
D5465-1 ^{PRELIN}	FWD LH OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	
D5478-1 ^{ST612}	AFT OEM Replacement Wearplate	1 Ea (1 ea)	90-Start up Operation	5004477
D5569-1	Skidtube Blade	1 Ea (1 ea)	90-Start up Operation	N/A
D5570-1 ^{ST546}	Blade Plug	1 Ea (1 ea)	90-Start up Operation	N/A
D5594-1	GH Bushing	6 Ea (6 ea)	90-Start up Operation	NA
D5594-3	GH Washer	6 Ea (6 ea)	90-Start up Operation	NA
NAS1149C0332R ²⁶⁶	Washer	8 Ea (8 ea)	90-Start up Operation	5104354
NAS1149C0832R ²⁶⁶	Washer	3 Ea (3 ea)	90-Start up Operation	5076013
NAS1291C8 ²⁶¹	Nut, Self Locking	3 Ea (3 ea)	90-Start up Operation	5112909
23111AG100LE ⁵⁷⁸	Washer	1 Ea (1 ea)	130-Packaging	5101932
ASNA0045BC100L ⁵⁵⁶	Nut, Castellated	1 Ea (1 ea)	130-Packaging	5109874
DHS411-101.3106 ^{engineering}	Metric Hex Head Aerospace Bolt	1 Ea (1 ea)	130-Packaging	5093539
EN2367-18028	Cotter Pin	1 Ea (1 ea)	130-Packaging	NA
MS21141S-06-05	Rivet	20 Ea (20 ea)	130-Packaging	5108056

N.O.
N.O.N
see deviation

Job Allocations

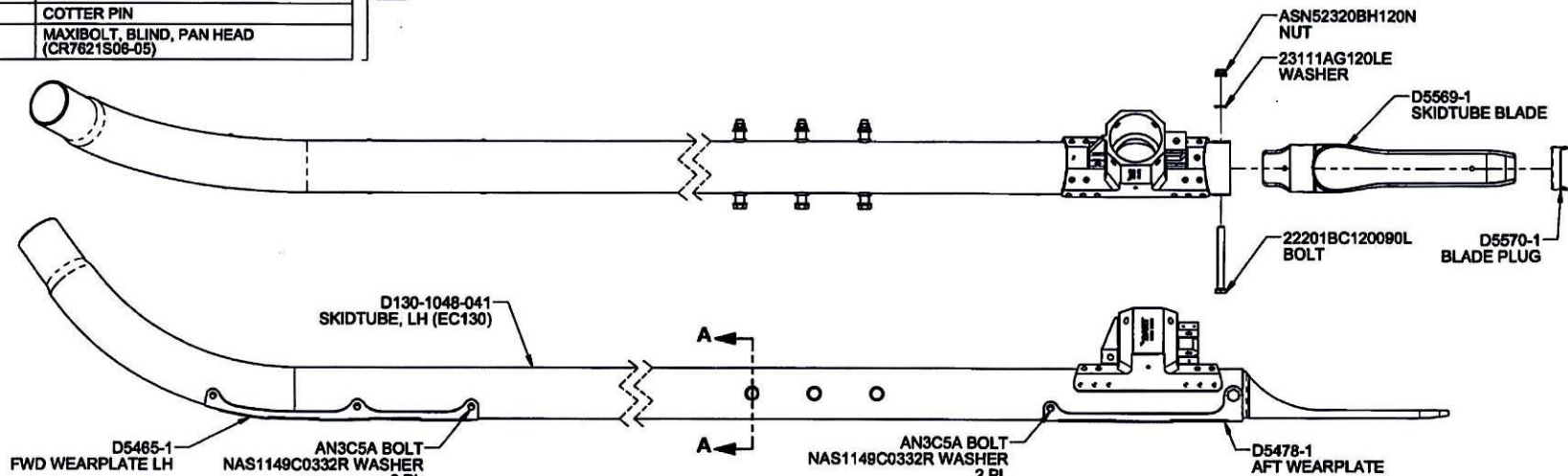
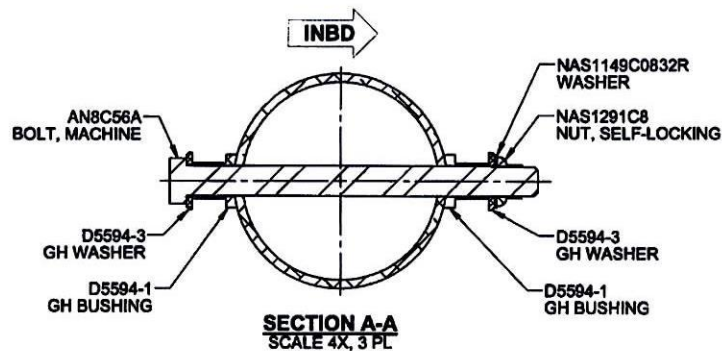
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	22201BC120090L	1	10	0
	23111AG120LE	1	0	0
	AN3C5A	8	1,850	0
	AN8C56A	3	30	0
	ASN52320BH120N	1	19	0
	D130-1048-041	1	2	0
	D5465-1	1	3	0
	D5478-1	1	6	0
	D5569-1	1	9	0
	D5570-1	1	8	0
	D5594-1	6	0	0
	D5594-3	6	0	0
	NAS1149C0332R	8	4,327	0
	NAS1149C0832R	3	400	0
	NAS1291C8	3	50	0
	23111AG100LE	1	10	0
	ASNA0045BC100L	1	12	0
130-Packaging	DHS411-101.3106	1	10	0
	EN2367-18028	1	0	0
	MS21141S-06-05	20	100	0

Part Specifications

Specifications could not be found.

Plex 10/3/18 1:36 PM dart.white.jesse

QTY -011	P/N	DESCRIPTION
X	D130-1048-011	SKIDTUBE INSTALLATION, LH (EC130)
1	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D5465-1	FWD WEARPLATE LH
1	D5478-1	AFT WEARPLATE
1	D5569-1	SKIDTUBE BLADE
1	D5570-1	BLADE PLUG
6	D5594-1	GH BUSHING
6	D5594-3	GH WASHER
1	22201BC120090L	BOLT
1	23111AG120LE	WASHER
8	AN3C5A	BOLT
3	AN8C56A	BOLT, MACHINE
1	ASN52320BH120N	NUT
8	NAS1149C0332R	WASHER
3	NAS1149C0832R	WASHER
3	NAS1291C8	NUT, SELF-LOCKING
1	23111AG100LE	WASHER
1	ASNA0045BC100L	NUT, CATELLATED
1	DHS411-101.3106	BOLT
1	EN2367-18028	COTTER PIN
20	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)



D130-1048-011 SKIDTUBE INSTALLATION, LH (EC130)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 25.41 lbs
- 8) HARDWARE NOT SHOWN. TO BE SHIPPED LOOSE.

RELEASED

2018 OCT 02
18-017

APPROVED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	18.05.08
DESIGN	NO		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP		
DATE	18.05.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D130-1048-011
REV. A
SHEET 1 OF 1
SCALE
TITLE
SKIDTUBE INSTL, LH (EC130)
NTS

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: <u>184194</u> Part No. <u>D130-1048-011</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐					
Date : <u>12/10/5</u>		Sequence #: _____		QTY Affected : _____			MRB (QSI042) <u>4P</u> DAS 12 12/10/5 9-89		
Description Work Order Deviation				Disposition				Completed By <u>4P</u> DAS 12 12/10/5 9-89 Lead hand / Supervisor DAS 9 9-89 18-10-05 QC / QA Coordinator DAS 9 9-89 18-10-05	
D5569-1 Skidtube blade and D5570-1 Blade plug not installed on D130-1048-011 or -012 skidtube assembly. GH Lugs (D5594-1/-3, NAS1291C8 Nut NAS1149C0832R washer, AN8C56A bdt) will not be installed on D130-1048-011/-012 skidtube assembly.				Acceptable for testing, use as is					
Root Cause				FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details: _____									

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>1884194</u> Part No. <u>D130-1048-011</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐							
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
D 5465-1 or D5465-2 Fwd wearplate not installed on D130-1048-011 or -012 Skid tube				Acceptable for testing use as is.				12 10/10/5 9-89 Completed By 12 10/10/5 9-89 Lead hand / Supervisor DAS 9 9-89 18-10-05 QC / QA Coordinator DAS 9 9-89 18-10-05			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%; vertical-align: top;"> ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled </td> <td style="width:33%; vertical-align: top;"> ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width:33%; vertical-align: top;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> <td style="width:33%; vertical-align: top;"> ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> </tr> </table>						☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread								
		Other/Details:									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>184194</u> Part No. <u>D130-1048-011</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒		
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
							DAS 12 9-89 <u>14/10/5</u>		
Description Work Order Deviation				Disposition					
no inventory 23111 AG120LE washer				use NAS 1149 D08635 washer instead					
				Completed By DAS 12 9-89 <u>14/10/5</u>					
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18.10-05</u>					
				QC / QA Coordinator Approval DAS 9 9-89 <u>18.10-05</u>					
Root Cause				FAULT CATEGORY					
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐		
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐		
				Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐		
				Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐		
				Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐		
				Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐		
				Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐		
				OTHER : ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐		
				Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐		
				Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐		
				Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐		
				Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐		
				Turning Sequence ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐		
				Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐		
				Misread ☐	Turning Sequence ☐				

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>184194</u> Part No. <u>D130-1048-011</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) DAS 12 12/10/5 9-89 Completed By DAS 12 10/10/5 9-89 Lead hand / Supervisor DAS 9 13-10-05 9-89 QC / QA Coordinator DAS 9 13-10-05 9-89	
Description Work Order Deviation EN2367-18028 cotter pin not picked as part of D130-1048-011/-012				Disposition Acceptable for testing, use as is			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details: _____					